

Date: Wednesday, 7/4/2007 3:42:34 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASS'Y	PROTOTYPE
Job Number : 33300	Part Number : D35311	
Estimate Number : 12522	Drawing Number : UNDER REVIEW	
P.O. Number : N/A	Project Number : N/A	
This Issue : 7/4/2007 S.O. No. : N/A	Drawing Revision : N/A	
Prsht Rev. : NC	Material : N/A	
First Issue : N/A Type : SMALL /MED FAB	Due Date : 7/11/2007	
Previous Run : 32207	Qty: 1 Um: Each	
Written By : <u>JA 07-07-12</u>		
Checked & Approved By : _____		
Comment : Est Rev:A New Issue 06-09.06 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S040	6061-T6 .040 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.3972 sf(s)/Unit Total: 0.3972 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M 100742

IB 07-07-06

CERTIFICATE OF CONFORMITY
REQUIRED

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: PREL

Prog Rev: PREL

2-Deburr if necessary

IB 07-07-06

MF 07-07-09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 07-07-09

SL

5.0	BRAKE NC	NC BRAKE
-----	----------	----------




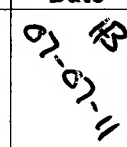
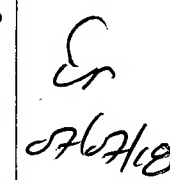

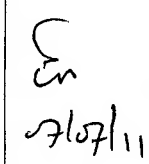
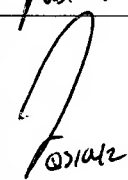
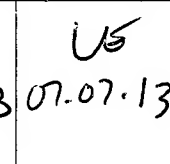
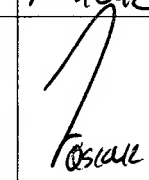
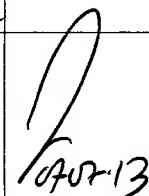
Comment: NC BRAKE

Bend as per Dwg D3531

SB 07/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3531-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR: <u>33300</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/11	#20	1 Part SCRAP wrong mat. used (0.050" instead of 0.040") R.C. Human Error		- SCRAP and destroy and replace with correct mat. - Remind employee to be more cautious when pulling mat. - BATCH # <u>M100742</u>	07-07-11 	En 07/07/18 		En 07/07/11 
07.07.13	#6	- BENT SHAPE DEVIATES FROM DWG - 2.32 ± 0.003 IS ACTUALLY 2.28 - PART IS SLIGHTLY TWISTED		- PART IS ACCEPTABLE FOR TEST STRUCTURAL TESTING PURPOSES ONLY	CB 07.07.13	US 07.07.13 		

NOTE: Date & initial all entries

Date: Wednesday, 7/4/2007 3:42:34 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSY

Job Number: 33300

Part Number: D35311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

BENT SHAPE OK

INSPECT WORK TO CURRENT STEP

FOR TESTING ONLY

CB

ENGINEERING

APPROVAL

Comment: INSPECT WORK TO CURRENT STEP



07-07-13
07-07-16

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

07-07-19

10.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE



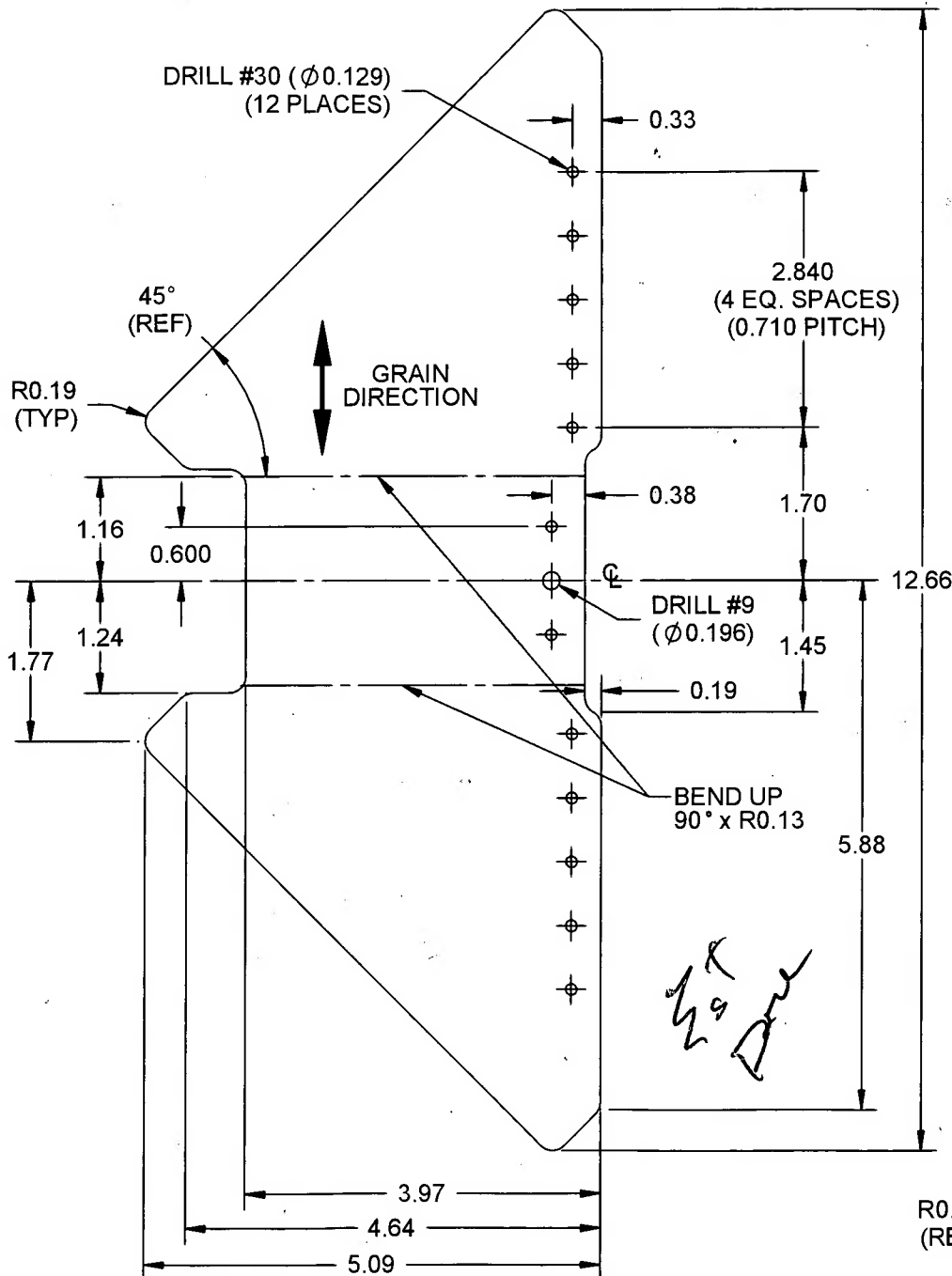
07.07.19

Job Completion

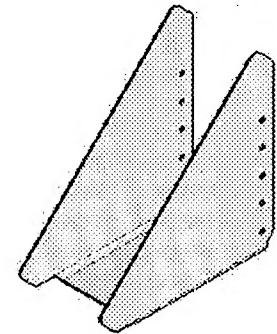


07/07/18

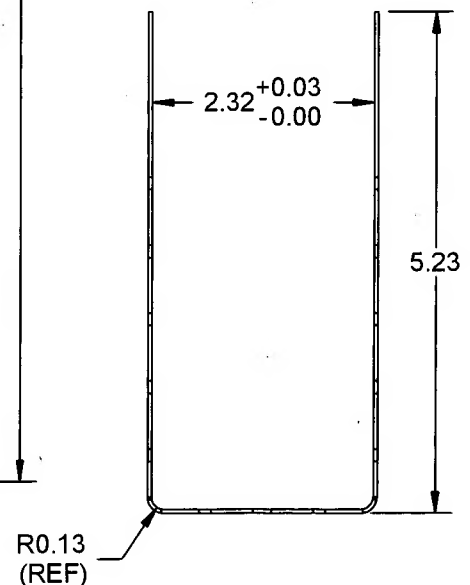
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3531-1F FLAT PATTERN



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
LE 07.06.22



D3531-1 BRACKET

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Receiving Report

Date: April 21/06
Supplier: Copper & Brass

Batch No: 1100742
Dart P/O: 1005

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☐
Shipment Complete: Yes ☐ No ☒
Q.C. Inspection ☐

Part No	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M50524325090	Sheet	96	0	0	96	
M6061T6B250X06000		48	0	0	48	
M6061T6B0500X0050		12	10	0	2	

ISR No: _____

Initials of receiver (if shipment OK) [Signature]

Production/Admin

Date: 06/04/25
Received/Costing: RCF1298

Initial: [Signature]

W:\090000\Forms\Purchase\RECREPORT rev B

Accounting:

Date: _____

AP/MR: _____

Initial: _____


DESCRIPTION OF MATERIAL	BILLING QTY	UNIT	PRICE	EXTENSION
RECT 6061-T6511 EXTR ALUMINUM BAR 019884 3/8 (+/- .008) X 1 (+/- .0 UZ3803 NO PROCESSING - 144" ML	1.00	PC	138.0700	138.07
PLEASE REMIT IN CANADIAN FUNDS		GST/HST		9.66
TOTAL \$				147.73

INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH
PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.

G.S.T. REG. NO. 14022393

REMIT BY: 05/15/06

TERMS: NET 30 DAYS

SHIP DATE 04/24/06 SHP		GROSS WEIGHT		QUOTE 30-161074-1		0 OF 10 TEST RESULTS	
ART AEROSPACE		WORK ORDER **		ORDER DATE 04/13/06 ORD			
SHIP TO ART AEROSPACE 270 ABERDEEN ST AWKESBURY ON CANADA		K6A 1K7		DELIVERY DATE 04/24/06 DEL		SHIP BRANCH 30 (04)	
						SELL BRANCH 30-TOR	
						WORK ORDER UZ3809	
				6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y			
				Copper and Brass Sales Canada A ThyssenKrupp Materials NA company 			
CUSTOMER SIGNATURE		DATE					
QUANTITY		ORDERED		SHIPPED			
INVENTORY		54.19 LB		52.00			
BILLING		2.00 PC		2.00			
WAREHOUSE							
PACKED WITH OTHER GOODS		UZ3800					
FINISHED GOODS LOCATION		WARN LABEL:1001					

PART DESCRIPTION 063496-4

061-T6 FLAT ALUMINUM SHEET, .040 X 48 X 144
 DART AEROSPACE, NO PROCESSING - 48" X 144" Mill
 dimensions.. Test Results Attn to: QA Department.
 SHEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL
 REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

SPECIAL INSTRUCTIONS

Shipping, do not place any packages or goods on top of our material."

SCRAP		FILLED BY SC		PACKED BY		Q/A AUDIT	
MAX SKID WEIGHT 100		LOADING INSTRUCTIONS HAND, CRANE, FORK, DOCK		MAXIMUM BUNDLE WEIGHT 200			
BASE	CASES	CUSHP	PKGS	SKIDS	BOLTS	TUBES	CTNS
FLAT	COILS						
INSPECTION RECORD							

TEST RESULTS

CERTIFICATE OF COMPLIANCE
 We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.
 Our products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds
 1-800-243-233-5682. We hereby certify that the material above complies with the following specifications:

050711	AMS 4027	ASTM-B209	ROHS COMPLIANT
QUANTITY UOM VENDOR	VEND PO HEAT/LOT	PCS : TAG NO	QUANTITY UOM VENDOR VEND PO HEAT/LOT
52.00 LB CORUS	0001837 7124901		